

OK 55.00

OK 55.00 is a reliable, high-quality, LMA electrode, particularly suitable for welding high strength low-alloy steels. The good, low-temperature impact strength of the weld metal should be noted. The weld metal is also very resistant to hot cracking. The electrode is also suitable for welding high strength ships steel, grades A, D and E.

Classifications:	SFA/AWS A5.1:E7018-1H4 R
Approvals:	CE EN 13479, DB 10.039.03, VdTÜV 00632, ABS 3Y H5, BV 3Y H5, RS 3Y H5, LR 3Ym H5, NAKS/HAKC 2.5-4.0mm, CWB E4918-1-H4, DNV-GL 3 YH5

Approvals are based on factory location. Please contact ESAB for more information.

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As welded	500 MPa (72.5 ksi)	590 MPa (85.6 ksi)	28 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
As welded	-45 °C (-49 °F)	85 J (63 ft-lb)
As welded	-50 °C (-58 °F)	80 J (59 ft-lb)

Typical Weld Metal Analysis %		
C	Mn	Si
0.06	1.5	0.5

Deposition Data						
Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/ kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
2.5 x 350 mm (3/32 x 12 in.)	80-110 A	23 V	0.64	66	64 s	0.9 kg/h (2.0 lb/h)
3.2 x 350 mm (1/8 x 14 in.)	110-140 A	23 V	0.62	41	72 s	1.2 kg/h (2.6 lb/h)
3.2 x 450 mm (1/8 x 18 in.)	110-140 A	24 V	0.69	30	88 s	1.4 kg/h (3.1 lb/h)
4.0 x 350 mm (5/32 x 14 in.)	140-200 A	23.2 V	0.62	28	72.5 s	1.77 kg/h (3.9 lb/h)
4.0 x 450 mm (5/32 x 18 in.)	140-200 A	24 V	0.71	19	94 s	2.0 kg/h (4.4 lb/h)
5.0 x 450 mm (3/16 x 18 in.)	200-270 A	24 V	0.72	13	94 s	3.0 kg/h (6.6 lb/h)
6.0 x 450 mm (1/4 x 18 in.)	215-360 A	25 V	0.71	9	98 s	4.0 kg/h (8.8 lb/h)